

# Work Order ID 106487

\*106487\*

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September-03-13 2:21:49 PM

Item ID: D3041-7 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Clamp  
 Start Date: 9/03/13 Start Qty: 40.00 \*40\* Cust Item ID:  
 Required Date: 9/10/13 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3041	Rev C								

100 BAND SAW 0.00  
 \*100\*  
 Bandsaw Memo 0.00  
 Jeaspa Bandsaw Cut D2423 Extrusion: 1.250" Long  
*ate umetic*

*CL 13/09/03*

110 HAAS CNC VERTICAL MACHINING #1 0.00  
 \*110\*  
 HAAS I *search* Memo 0.00  
 HAAS CNC vertical machine #1 Check for cracks while loading into the machine  
 Machine as per Folio FA933 and Dwg D3041 *P/O: 24174*  
 DWG REV: *machine as pending D3041 REV.C*  
 FOLIO REV:

*CL 13/09/03 40*

120 QC2- Inspect parts off machine FAI/FAIB 0.00  
 \*120\*  
 QC *read* Memo 0.00  
 Quality Control

*CL 13/09/03 40*

*read + inspect  
 attached copy to W/O.*

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Item ID: D3041-7 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Clamp  
 Start Date: 9/03/13 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 9/10/13 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC Inspect parts - second check  Memo	0.00 DAS 27 9-89 139 20				40			
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				40			13-9-23
150 <b>*150*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 8:00 FINISH TIME: 8:30 320°F	0.00 0.00				40			13/09/24

m126125

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Item ID: D3041-7 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Clamp  
 Start Date: 9/03/13 Start Qty: 40.00 \*40\* Cust Item ID:  
 Required Date: 9/10/13 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
*160*									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>ST466</u>	0.00							
*170*									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

40x / 11/03/13/21

40x / 13-09-24

13/09/26  
 MF 13-9-25

# Picklist Print

September-03-13 2:21:48 PM

Page 1

Work Order ID: 106487  
 Parent Item: D3041-7  
 Parent Item Name: Clamp

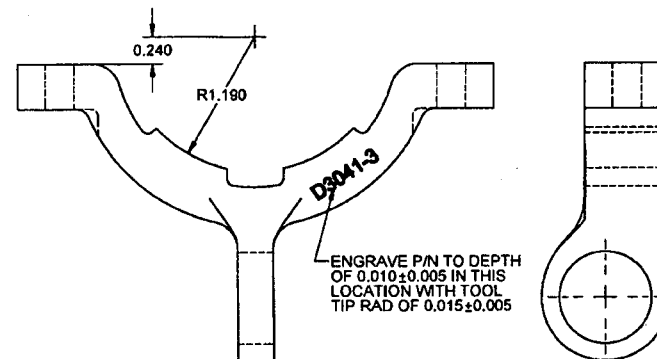
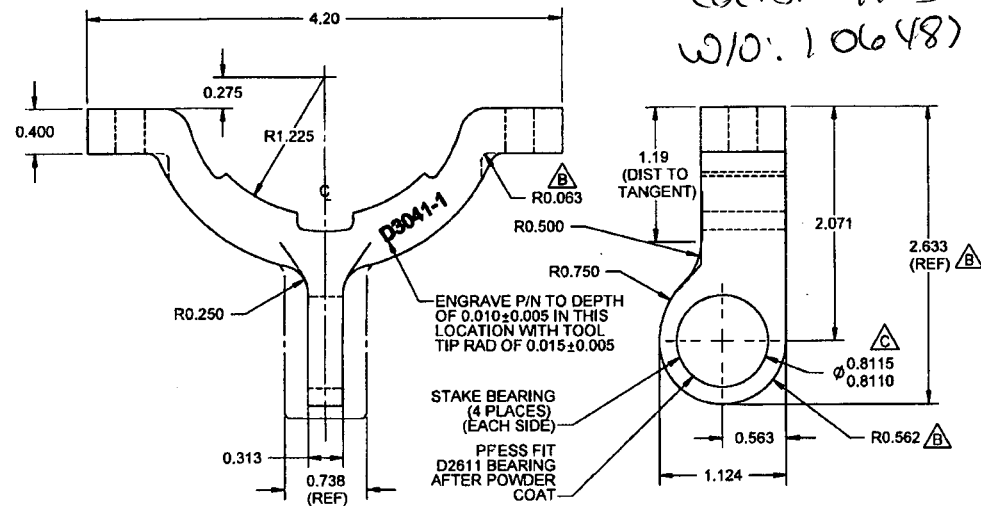
Start Date: 9/03/13  
 Start Qty: 40.00

Required Date: 9/10/13  
 Required Qty: 40.00

Comments: IPP: A01.07.11New IssueSM/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion	<i>A</i>	Manufactured	No			110	f	221.5000	0.1042	4.3873684			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT006		221.5							
				87953		221.5							
D3041-7P Clamp		Purchased	No				Each	0.0000		40		<i>9/13/13</i>	<i>(40)</i>

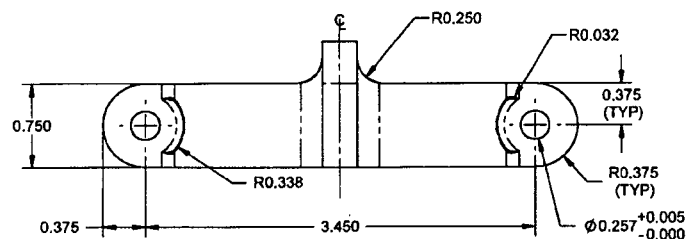
CD 13/09/03  
W/O: 10648)



DEO ATTACHED

RELEASED

06.11.17



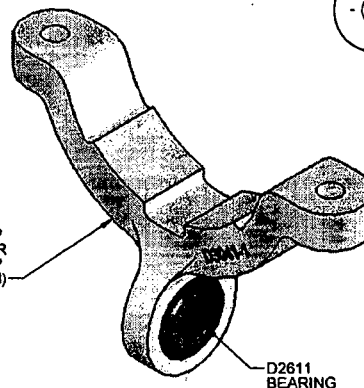
**D3041-1 CLAMP**

**D3041-3 CLAMP**  
(SAME AS D3041-1  
EXCEPT AS SHOWN)

**NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) STAKE D2611 BEARING AFTER POWDER COAT
- 7) PART IS SYMMETRIC ABOUT  $\phi$

D3041-1 CLAMP  
(SHOWN) OR  
D3041-3 CLAMP  
(NOT SHOWN)

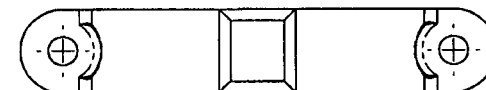
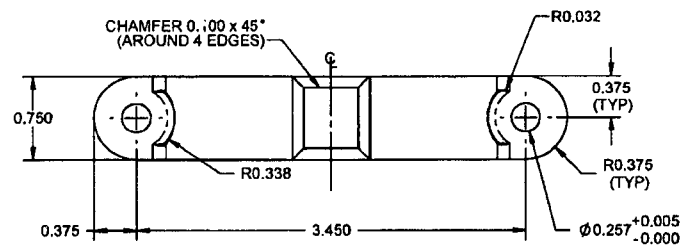
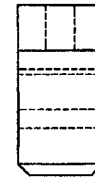
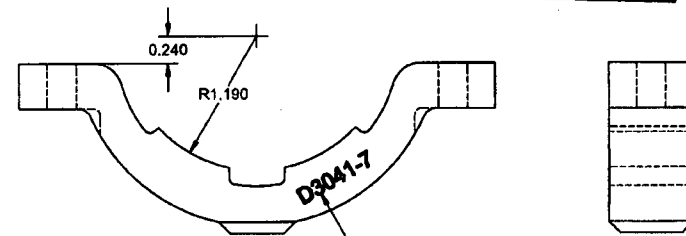
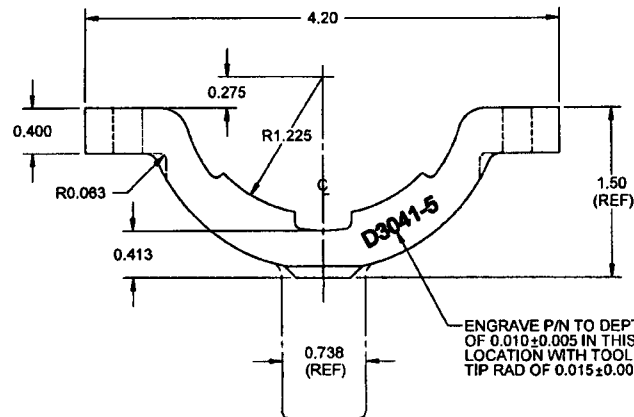


C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5-7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. <b>D3041</b>
DATE	06.10.18	TITLE <b>CLAMP</b>
COPYRIGHT © 2001 BY DART AEROSPACE USA, INC.		REV. C SHEET 1 OF 2 SCALE 1:1
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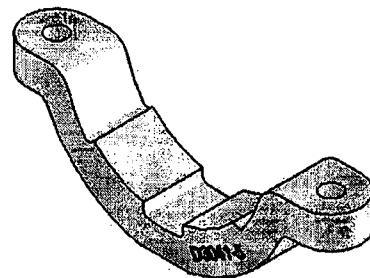
# DEO ATTACHE

## RELEASED

06.11.17



**D3041-7 CLAMP**  
(SAME AS D3041-5 EXCEPT AS SHOWN)

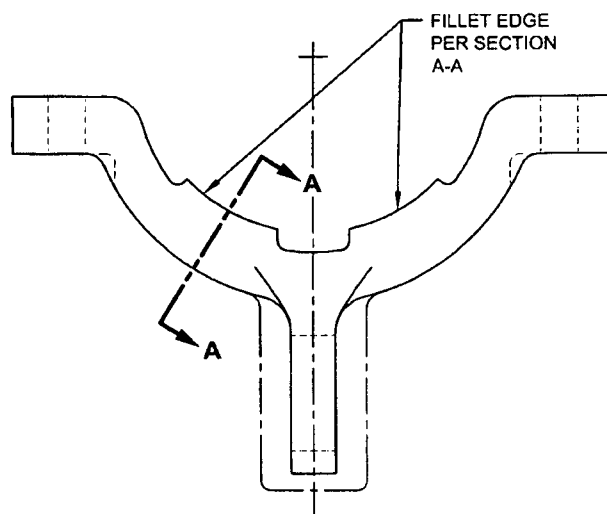


- NOTES:**
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
  - 6) PART IS SYMMETRIC ABOUT C

DESIGN 90	DRAWN BY CB	DART AEROSPACE USA, INC.	
CHECKED [Signature]	APPROVED [Signature]	PORT HADLOCK, WA	
	DRAWING NO. D3041	REV. C	
DATE 06.10.18	TITLE CLAMP	SHEET 2 OF 2	SCALE 1:1
COPYRIGHT © 2001 BY DART AEROSPACE USA, INC.			
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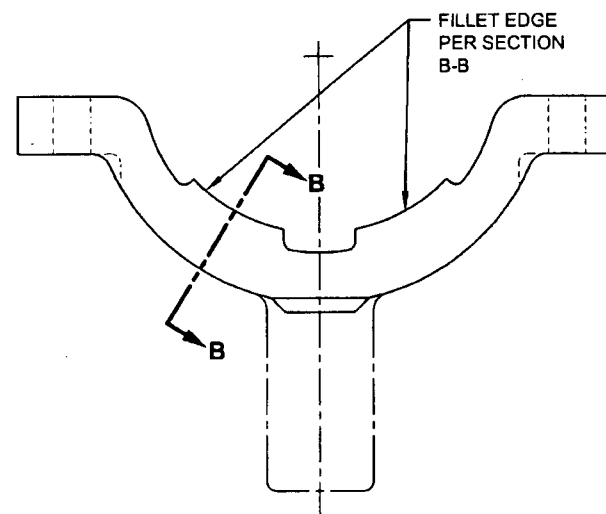
DRAWING NO. D3041	TITLE CLAMP	REV. C	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



**D3041-1 CLAMP**

**D3041-3 CLAMP**



**D3041-5 CLAMP**

**D3041-7 CLAMP**



R0.060 MIN - R0.10 MAX  
2PL

**SECTION A-A**

SCALE 2X

**SECTION B-B**

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

**RELEASED**  
09/07/07

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20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 19490  
**Date:** Sep 19, 2013  
**Page:** 1

<b>Sold to:</b>  <b>Dart Aerospace Ltd.</b> Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 21174	<b>Sold By:</b> Dewar, Eric
<b>Shipped By:</b> your truck	<b>Ship Date:</b> Sep 19, 2013

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-3 Crosstube Lug as per drawing D3910 REV.B	Each	24		24
D3041-5 Clamp as per drawing D3041-5P REV.C	Each	40		
D3041-7 Clamp as per drawing D3041 REV.C	Each	40	40	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		





20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3041-7	Lug	PO 21174

MATERIAL: supplied by DART B87953

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris", is written over the printed name.

Jan Norris

Vankleek Hill, September 19, 2013